DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-014945 Address: 333 Burma Road **Date Inspected:** 06-Jun-2010

City: Oakland, CA 94607

OSM Arrival Time: 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: ZPMC and ABF **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A **Delayed / Cancelled:**

34-0006 **Bridge No: Component:** OBG section 13

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

Bay #13

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on 100mm wall thick CJP weld. The CJP weld is attached to two base plates of 13AE section of east line. The weld number and plate number are BP3032-001-005/PL3221C and PL3222C (side A). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Bay #14

Caltrans QA Inspector observed two welders performed FCAW CJP weld process on stiffeners that connected to steel plate PL3383B of side plate #3091B. The minimum preheat and maximum interpass temperature requirements for FCAW CJP weld are 110C degree and 230 C degree. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Caltrans QA inspector observed a fit up groups performed fit up and SMAW tack weld process on T-joint fillet weld. The T-joint is attached to stiffeners and 22mm wall thick plate # PL3884E and PL3140E of 13AE section of side plates. The side plate number is SP3092E and SP3060E. A numerous temporary tack welds have been welded attach between side plate and stiffeners after adjusted and secured by hand jack. The fit up SMAW tack welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

Bay #16

Caltrans QA Inspector observed a welding operator in process of semi-automatic SAW on CJP butt joint weld. The CJP weld is attached to 60mm wall thick base plate of 13AE section of west line. The weld number and plate

WELDING INSPECTION REPORT

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number are BP3074-001-003/PL3364C and PL3363C (side A). The semi-automatic saw process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted. Caltrans QA inspector observed a worker performed FCAW root pass process on CJP butt joint weld. The CJP weld is attached to 100mm wall thick base plate to base plate for 13AE section of east line. The FCAW root pass welding process were monitored and recorded by ZPMC and ABF QC inspector. Base on Caltrans QAI observation, no discrepancies were noted.

CLOSING STATEMENT

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

As notes within report above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer